Work Order ID 74531

Tuesday, October 04, 2011 8:19:29 AM

Item ID: D2022-103 **Accept** **Setup Start** **Stop**

Revision ID:

Item Name: Spacer

Start Date: 9/30/2011 **Start Qty:** 40.00 **Cust Item ID:**

Required Date: 10/14/2011 **Req'd Qty:** 40.00 **Customer:**

Reference:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Draw Nbr	Revision Nbr
D2022	Rev ...

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100		0.00				40	∅		
Hardinge Hardinge CNC Lathe Small	**Memo** Note:.323" dia drill 1-Turn as per folio FA207 & dwg FOLIO REV: A DWG REV: A/a 2-Deburr as required	0.00							
110	QC2- Inspect parts off machine FAI/FAIB	0.00				40	∅		
QC Quality Control	**Memo**	0.00							

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID 74531

Tuesday, October 04, 2011 8:19:29 AM

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Revision ID: **Stop**

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Stop

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				40	ø		
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: 5	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

11/10/10

HOX SP 11-10-11.

11/10/11

11-10-11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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NOTE: Date & initial all entries

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Picklist Print

Tuesday, October 04, 2011 8:19:36 AM

Work Order ID: 74531

Parent Item: D2022-103

Parent Item Name: Spacer

Start Date: 9/30/2011 **Required Date:** 10/14/2011

Start Qty: 40.00 **Required Qty:** 40.00

Comments: IPP REV:A 11.05.11 new DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.750 6061-T6 Round Bar .750"		Purchased	No			100	f	7.5530	0.0189	0.795789			

11/10/06

Location	Loc Qty	Loc Code	
MAT013	7.553		
112442	0.796		
116406	0.617		
117481	2.76		.250'
118106	3.38		1.125'

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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DART AEROSPACE LTD	Work Order:	74531
Description: Spacer	Part Number:	D2022-103
Inspection Dwg: D2022 **Rev:** --		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	.738	✓		CNC 02	
0.032 x 45°	+/-0.05°	0.032x45°	✓			
0.226	+/-0.010	.227	✓			
Ø0.323	+0.006/-0.001	.323	✓			

Measured by:	[signature]	Audited by:	[signature]	Prototype Approval:	N/A
Date:	11/10/06	Date:	11/10/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.07.07	New Issue	KJ/JLM	[signature]

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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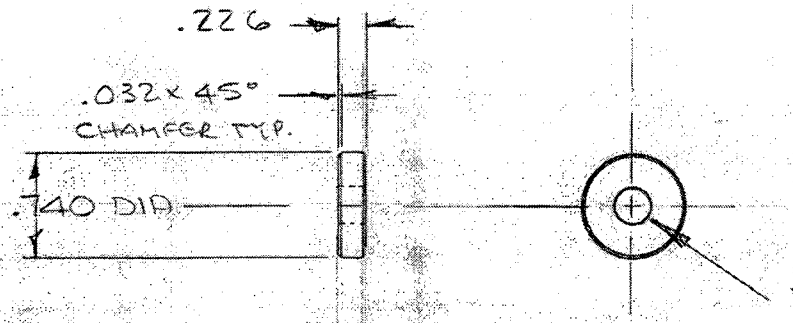
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74531
M.L.J
11/10/04

RELEASED
9/01/19 BW



DRILL 'F' (.257) DIA. IN -101
DRILL P (.323) DIA IN -103

D2022-101
D2022-103

MAT'L: ALUMINUM 6061-T6 (QQ-A-225/8)

D2022

DO COPY ISSUED

PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC./VENDOR
D2022-103		SPACER 5/16	ALUM 6061-T6	QQ-A-250/8
D2022-101		SPACER 1/4	ALUM 6061-T6	QQ-A-250/8

REVISION
DRAWN
APPROVED
DESCRIPTION OF CHANGE

THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.

REQUIREMENTS — UNLESS OTHERWISE SPECIFIED

GENERAL
1. DIMENSIONS ARE IN INCHES
2. SURFACE ROUGHNESS 125
3. REMOVE BURR EDGES .015 MAX
4. THREADS PER MIL - S - 7742
5. HOLES PER AND 10387

LIMITS
1. TOLERANCES — .XX ± .030
.XXX ± .010
2. ANGLES ± 30'
3. PARALLELISM ± .0025
4. ECCENTRICITY .005 MAX
5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005

REPORT ALL DISCREPANCIES — DO NOT SCALE

RIVET CODE SHALL BE PER NAS 523

BASIC CODE: DIA. DASH NO. 9=HEAD NEAR SIDE P=HEAD FAR SIDE
D=DIMPLE DIGIT=NO OF SHEETS C=COUNTERSINK LENGTH DASH NO W=BRIDGEFIELD

BASIC CODES
B=MS20470D
BW=MS20426AD

QTY REQUIRED

APPROVAL

CONTRACT NO.
DRAWN BRADLEY
DESIGN BRADLEY
DATE 9/06/19
STRESS
CHECKED
CLIENT

DART AERO ACCESSORIES INC

CLIENT

TITLE SPACERS

CODE

DWG NO. D2022

REV.

SCALE 1:1 SHT 1 OF 1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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